

Work Order ID 81958

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81958

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Item ID: D2274

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Radius Block

Start Date: 21/03/2012 Start Qty: 400.00

400

Gust Item ID:

Required Date: 04/04/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr.

D2274

Rev F

100

0.00

100

SHEAR

Shear

Shear

Memo

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

0.00

45 blanks of 9" long

SL 12/03/20

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio D2274

0.00

SL 12/03/30
SL 12/03/31

400

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

SL 12/03/30
SL 12/03/31

400

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2274 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 21/03/2012 Start Qty: 400.00 ***400*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 400.00 ***400*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>and 12/04/01</i>		<i>400</i>	<i>10</i>		
140 *140* Small Fab Small Fab	Small Fab Memo TumbleDeburr any rough edges after tumbling	0.00 0.00		<i>B12-4-8 (400)</i>					
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>400</i>	<i>BL</i>	<i>12-4-9.</i>	

W/O:		WORK ORDER CHANGES					
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Item ID: D2274 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 21/03/2012 Start Qty: 400.00 ***400*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 400.00 ***400*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				400x	0	12/04/09	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location ST7 Memo	0.00 0.00				(400x)		SP 12-04-10.	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/4/10	

12-04-10
400

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 81958

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Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	116.5680	0.0916	38.56842			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

**

36 12/03/29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	11.168	
116406	2.75	
117653	8.418	
MAT003	105.4	
119653	41.4	
120603	64	

38.6

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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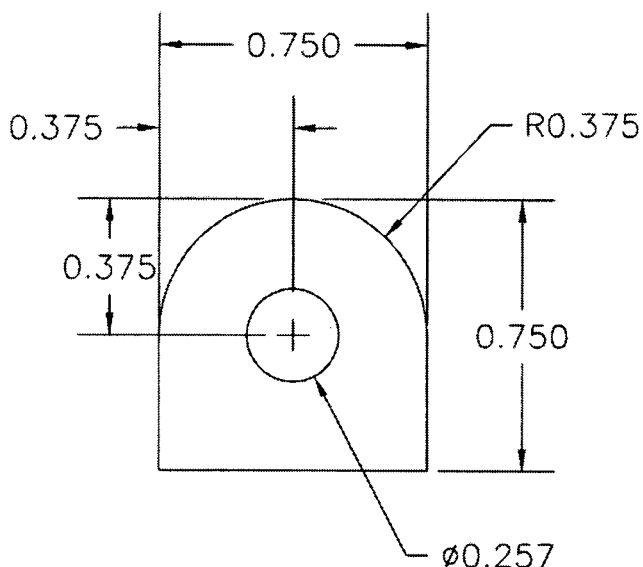
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11	TITLE RADIUS BLOCK		SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/13 KE



0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81958 MC5
12/03/21

W/O:		WORK ORDER CHANGES					
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